

Date: Wednesday, 12/5/2007 12:57:43 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: FLOAT SKIDTUBE		
Job Number	: 35742			Part Number	: D412742013		
Estimate Number	: 10366			Drawing Number	: N/A		
P.O. Number	:			Project Number	: N/A		
This Issue	: 12/5/2007 S.O. No. :			Drawing Revision	: N/A		
Prshtr Rev.	: NC			Material	:		
First Issue	: / / Type : LANDING GEAR			Due Date	: 12/30/2007 Qty: 1 Um: Each		
Previous Run	: 35741						
Written By	: <u>11/07/12 OS</u>						
Checked & Approved By	:						
Comment	: Est Rev. A 05.10.13 New Issue KJ/JLM						
	Est Rev.B 06-06-08 As per DS19336 JLM						
	Est Rev.C 07-12-03 ECN 1072 DD verified by:JLM						



Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL <i>✓ 08/01/14</i>
2.0	35742A	FLOAT SKID ASSEMBLY <i>35742 A 08/01/16 X1</i>
3.0	PACKAGING 1	PACKAGING RESOURCE #1 <i>08/01/16 X1</i>
4.0	D2571	Saddle, Fwd, Out <i>34367</i>
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Qty Part Number Description Batch	
	1 D2571 Saddle Fwd Outside	
5.0	D2572	Saddle, Fwd, In <i>35932</i>
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Qty Part Number Description Batch	
	1 D2572 Saddle Fwd Inside	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 12/5/2007 12:57:43 PM
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Customer: CUDAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE

Job Number: 35742

Part Number: D412742013

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 D2573 Saddle, Aft, Out



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2573 Saddle Aft Outside 36324

7.0 D2574 Saddle, Aft, In



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2574 Saddle Aft Outside 35934

8.0 D2876 Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2876 Saddle Spacer 33543

9.0 D2877 Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2877 Saddle Spacer B36276

10.0 D34031 Bushing



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number Description Batch

16 D3403-1 Bushing B35634

11.0 D2747 Set Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 D2747 Bolt 35758

8/1/22 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Drawing Name: FLOAT SKIDTUBE

Job Number: 35742

Part Number: D412742013

Job Number:



Seq. #: Machine Or Operation:

Description :

12.0 D35331 Set Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Set Screw

328093

LS

13.0 AN4C6A Bolt



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number Description Batch
16 AN4C6A Bolt *M105793*

LS

14.0 AN4C52A BOLT



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch
8 AN4C52A Bolt *M19512*

LS

15.0 AN6C12A BOLT



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch
8 AN6C12A Bolt *104289*

LS

16.0 D36723 PHENOLIC WASHER



Comment: Qty.: 32.0000 Each(s)/Unit Total : 32.0000 Each(s)

PHENOLIC WASHER

34471

LS

17.0 AN960C416L WASHER



Comment: Qty.: 32.0000 Each(s)/Unit Total : 32.0000 Each(s)

WASHER

M105793

LS

18.0 D36729 PHENOLIC WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

PHENOLIC WASHER

335523

12/5/2007 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE

Job Number: 35742

Part Number: D412742013

Job Number:



Seq. #: Machine Or Operation:

Description :

19.0 AN960C616L WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

WASHER

M18918

20.0 D367211 PHENOLIC WASHER



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

PHENOLIC WASHER

MR B35 J24

21.0 MS210434 Nut

Nut



Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)

Nut

M106421

22.0 AN4C7A Bolt

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: *M106427*

B2

23.0 D34033 Bushing

Bushing



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description

8 D3403-3

Batch

34569

B2

24.0 D3405041 Lug Assembly

Lug Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description

1 D3405-041

Batch

735779

8/1/28 50 (1)

25.0 D3405043 Lug Assembly

Lug Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description

1 D3405-043

Batch

34841

8/01/31 (1)
8/01/22 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE

Job Number: 35742

Part Number: D412742013

Job Number:



Seq. #: Machine Or Operation:

Description :

26.0 AN4C46A BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	AN4C46A	Bolt	M19529

27.0 MS210434 Nut

Nut



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
5	MS21043-4 Nut		M106421

28.0 D3407041 Tow Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3407-041	TOW RING	B35780

29.0 D34173 Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3417-3	WASHER	33319

30.0 D34561 washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3456-1	WASHER	33276

31.0 AN3C37A BOLT



Comment: Qty.: 1.0000 EACH(s)/Unit Total : 1.0000 EACH(s)

BOLT

M106171

P-8/01/22 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE

Job Number: 35742

Part Number: D412742013

Job Number:



Seq. #: Machine Or Operation:

Description :

32.0 AN3C40A BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
BOLT M106169

33.0 AN3C41A BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
BOLT M106169

34.0 AN3C42A BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
BOLT M106169

35.0 AN3C43A BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
BOLT M106295

36.0 AN3C46A BOLT



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)
BOLT M106169

37.0 AN960C10L washer



Comment: Qty.: 26.0000 Each(s)/Unit Total : 26.0000 Each(s)
washer M106852

38.0 MS210433 Nut



Comment: Qty.: 13.0000 Each(s)/Unit Total : 13.0000 Each(s)
Nut M106781

39.0 QC4 INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

12/5/07 12:57:43

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 06/02/01
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 12/5/2007 12:57:43 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE

Job Number: 35742

Part Number: D412742013

Job Number:



Seq. #: Machine Or Operation:

Description :

40.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-742-013

Location: NEVR 10/13/01 (1)

41.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

10/02/01

Job Completion



10/01/01

POSITIVE RECALL

EFFECTIVE 07/21/01

RELEASED 10/01/01

AUTH 1

DATE 08/01/01

B35742A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 12/5/2007 12:57:43 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: FLOAT SKIDTUBE		
Job Number	: 35742					
Estimate Number	: 10366					
P.O. Number	:			Part Number	: D412742013	
This Issue	: 12/5/2007		S.O. No. :	Drawing Number	: N/A	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: / /		Type :	Drawing Revision	: N/A	
Previous Run	: 35741			Material	:	
Written By	:			Due Date	: 12/30/2007	
Checked & Approved By	:			Qty:	1 Um: Each	
Comment	: Est Rev: A 05.10.13 New Issue KJ/JLM					
	Est Rev:B 06-06-08 As per DSI9336 JLM					
	Est RevC 07-12-03 ECN 1072 DD verified by:JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	DC	DOCUMENT CONTROL	
		Comment: DOCUMENT CONTROL Photocopy bluefile and create labels per PPP D412-742-013 CHG003	071206 JLM
2.0	35742A	FLOAT SKID ASSEMBLY	
		Comment: Sub-Component FLOAT SKID ASSEMBLY D412-742-043 B	
3.0	PACKAGING 1	PACKAGING RESOURCE #1	
		Comment: PACKAGING RESOURCE #1 Pick Packing Kit	REFERENCE ONLY
4.0	D2571	Saddle, Fwd, Out	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Qty Part Number Description Batch	
		1 D2571 Saddle Fwd Outside	
5.0	D2572	Saddle, Fwd, In	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Qty Part Number Description Batch	
		1 D2572 Saddle Fwd Inside	

Date: Wednesday, 12/5/2007 12:57:58 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001	Dart Helicopters Services	Drawing Name	FLOAT SKID ASSEMBLY
Job Number	35742A			
Estimate Number	10756			
P.O. Number	:		Part Number	D412742043
This Issue	12/5/2007	S.O. No. :	Drawing Number	D3391 REV G
Prsht Rev.	NC		Project Number	N/A
First Issue	/ /	Type : LANDING GEAR	Drawing Revision	0G
Previous Run	35741A		Material	:
Written By	:		Due Date	12/30/2007
Checked & Approved By	10/07 12 05		Qty:	1 Um: Each
Comment	Est Rev A	05.10.13 New Issue	KJ/JLM	
	Est Rev B	06.02.13 ECN 773 dwg @ rev.D	EC	
	Est Rev:C	07-05-28 As per Rev F	JLM	
	Est Rev:D	07-12-04 ECN 1072	DD verified	
		by:JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL 
2.0	HAND FINISHING1	HAND FINISHING RESOURCE #1 

Comment: HAND FINISHING RESOURCE #1

1-Spray inside tube of D3391-021/-023/-025 with LPS-3 as per Dwg D3391
 A/R LPS-3 M105005

2-Install tubes together and seal them all the way around using Sikaflex 241/291. Ensure tube ends line-up with saddle holes for proper alignment. using 7/16" "T" Pins.

A/R Sikaflex-241/-291 M105585
 Expiry date: 08-07

3-Install wearplates as per Dwg D3391. Ensure that plastic washers are against wearplate, then topped with the SS washer. Coat bolts with LPS "procyon".

Seal all bolts with sikaflex except ones with inserts on inside of tube ,hand tighten only bolts with no sikaflex.
 A/R LPS Procyon M104251
 A/R Sikaflex-241/-291 M105585

Expiry date: 08-07

4-Remove "T" pins once sikaflex is dry.

5-Coat all exposed hardware with LPS Procyon. Remove any excess off with MEK degreaser.

10/08-01-03 pk

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 12/5/2007 12:57:58 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKID ASSEMBLY

Job Number: 35742A

Part Number: D412742043

Job Number:



Seq. #: Machine Or Operation:

Description :

3.0 D3391023 Mid Tube Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

Qty Part Number Description

Batch

1 D3391-023 Mid Tube Assembly

B33637 * 981

4.0 D3391025 Aft Tube Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

Qty Part Number Description

Batch

1 D3391-025 Aft Tube Assembly

B35772

* all

5.0 D35641 WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: B33243

all

6.0 D35661 GASKET



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

GASKET

Batch: B36339

all

7.0 D35643 WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

B34052

all

8.0 D35645 WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

B36111

all

9.0 D35665 GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: B34354

* all

08-02-01

①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 28/02/01
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 12/5/2007 12:57:58 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKID ASSEMBLY

Job Number: 35742A

Part Number: D412742043

Job Number:



Seq. #: Machine Or Operation:

Description :

10.0

AN3C4A

BOLT



Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)

BOLT

Batch: M106277

46

11.0

AN3C6A

BOLT



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

BOLT

Batch: M105057

46

12.0

AN3C7A

BOLT



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

BOLT

Batch: M105906

46

13.0

AN960C10L

washer



Comment: Qty.: 44.0000 Each(s)/Unit Total : 44.0000 Each(s)

washer

Batch: M106578

X

08-01-03

x1

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-742-043

Location:

PPP Rev:

35742

8/1/31 (x) SP

16.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



11/01/31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

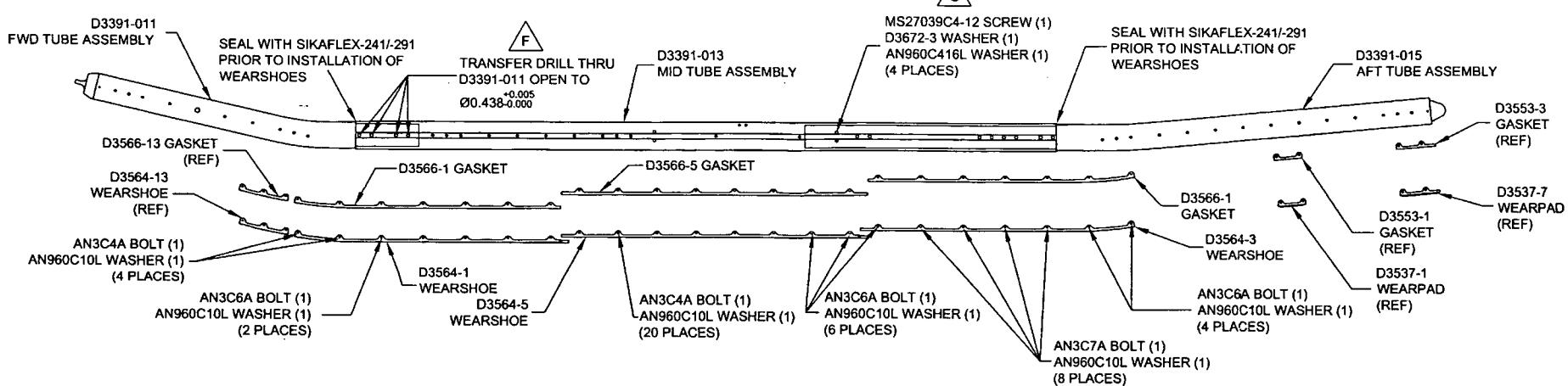
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

D

RELEASED
(27-11-06)

D3391-041 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
1	D3391-041	FLOAT SKIDTUBE ASSEMBLY
1	D3391-011	FWD TUBE ASSEMBLY
1	D3391-013	MID TUBE ASSEMBLY
1	D3391-015	AFT TUBE ASSEMBLY
1	D3564-1	WEARSHOE
1	D3564-2	WEARSHOE
1	D3564-3	WEARSHOE
2	D3566-1	GASKET
1	D3566-5	GASKET
4	D3672-3	WASHER
24	AN3C4A	BOLT
12	AN3C6A	BOLT
8	AN3C7A	BOLT
44	AN960C10L	WASHER
4	MS27039C4-12	SCREW
4	AN960C416L	WASHER

UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 ENGINEERING
 RETURN TO
 SHOP COPY
 NO. 35
 WORK ORDER
 WITHOUT NOTICE
 NO. 7424

GENERAL NOTES

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH
 AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH
 LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS
 OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL $\varnothing 0.297$ SIZE HOLES
 FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT
 WHERE INDICATED.

G	REPLACE NAS INSERTS W/ AELS INSERTS SWITCH TO D3670-XXXX SPACERS FOR INSTALLING FLOAT BAGS, DWG REORGANIZED FOR CLARITY	DC	07.07.31
F	ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011/-021	PH	07.01.18
E	CHANGE TOLERANCE, EASE MANUFACTURE	PH	06.04.25
D	UPDATE TOLERANCE, CHANGE HOLE SIZE	PH	06.01.23
C	LENGTHEN AFT EXTENSION	PH	05.09.27
B	DRAWING UPDATES	PH	05.06.10
A	NEW ISSUE	PH	05.02.07
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>PH</i>		
DRAWN	<i>SC</i>		
CHECKED	<i>PH</i>		
MFG. APPR.	<i>PH</i>		
APPROVED	<i>PH</i>		
DE APPR.	<i>PH</i>		
DART AEROSPACE USA, INC			
PORT HADLOCK, WA			
DRAWING NO.	D3391	REV. G	
SHEET 1 OF 8			
TITLE	412 FLOAT SKIDTUBE	SCALE	NTS
DATE	07.07.31		

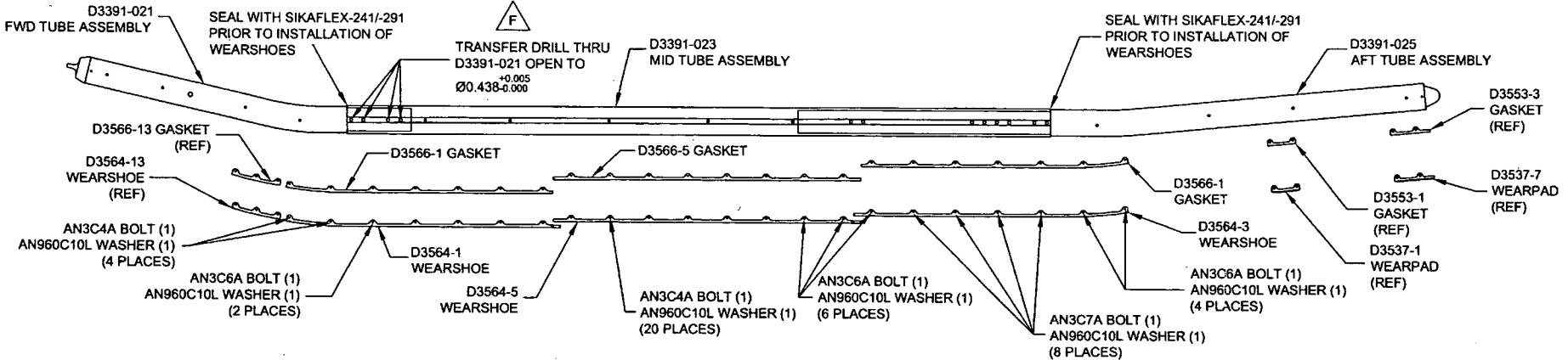
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D3391-043 ASSEMBLYD3391-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
-043	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1	D3391-021	FWD TUBE ASSEMBLY
1	D3391-023	MID TUBE ASSEMBLY
1	D3391-025	AFT TUBE ASSEMBLY
1	D3564-1	WEARSHOE
1	D3564-3	WEARSHOE
1	D3564-5	WEARSHOE
2	D3566-1	GASKET
2	D3566-5	GASKET
24	AN3C4A	BOLT
12	AN3C6A	BOLT
8	AN3C7A	BOLT
44	AN960C10L	WASHER

GENERAL NOTES

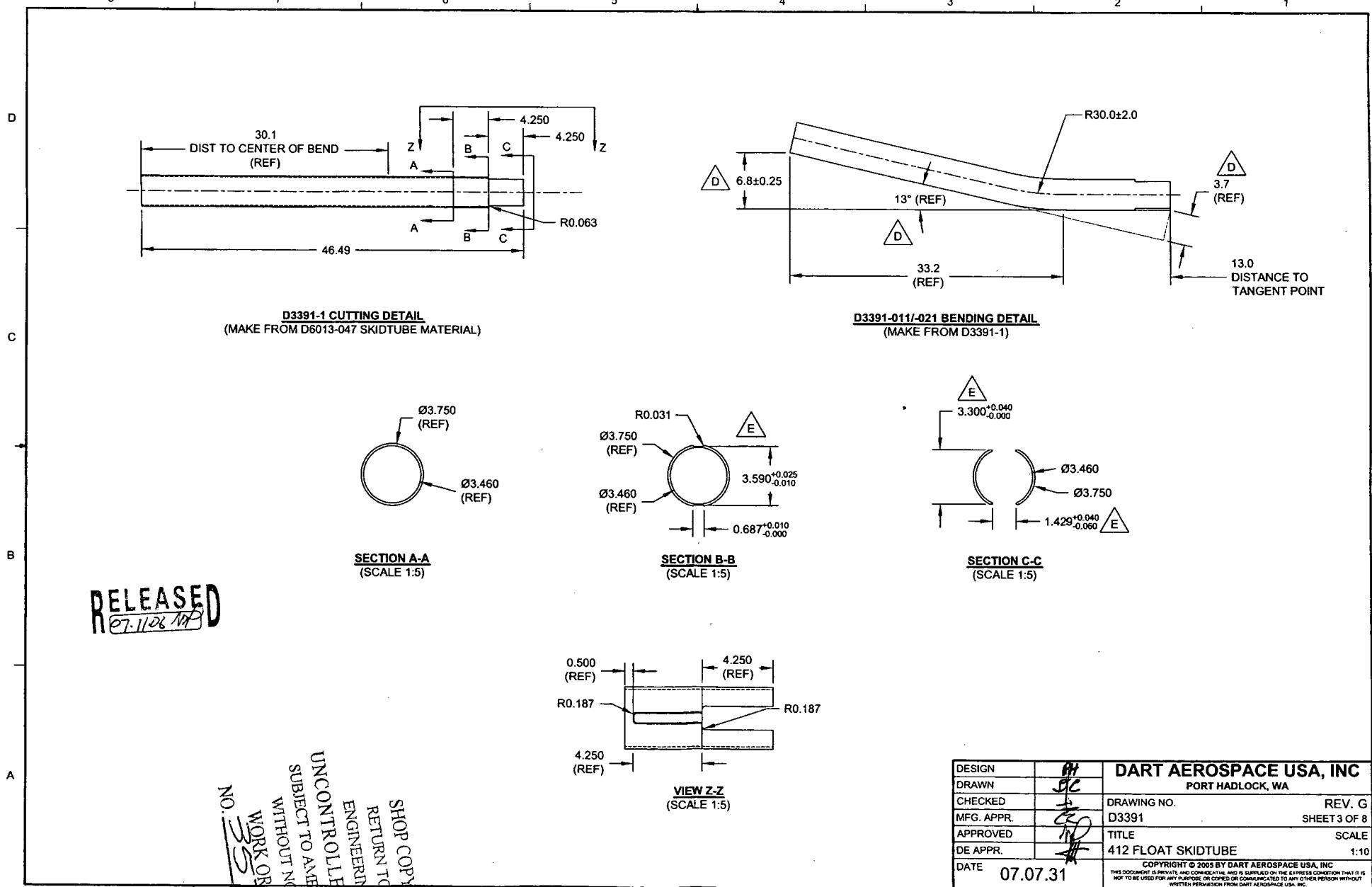
- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH
AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH
LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS
OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES
FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT
WHERE INDICATED.

8 7 6 5 4 3 2 1

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WORK ORDER
NO. 351424

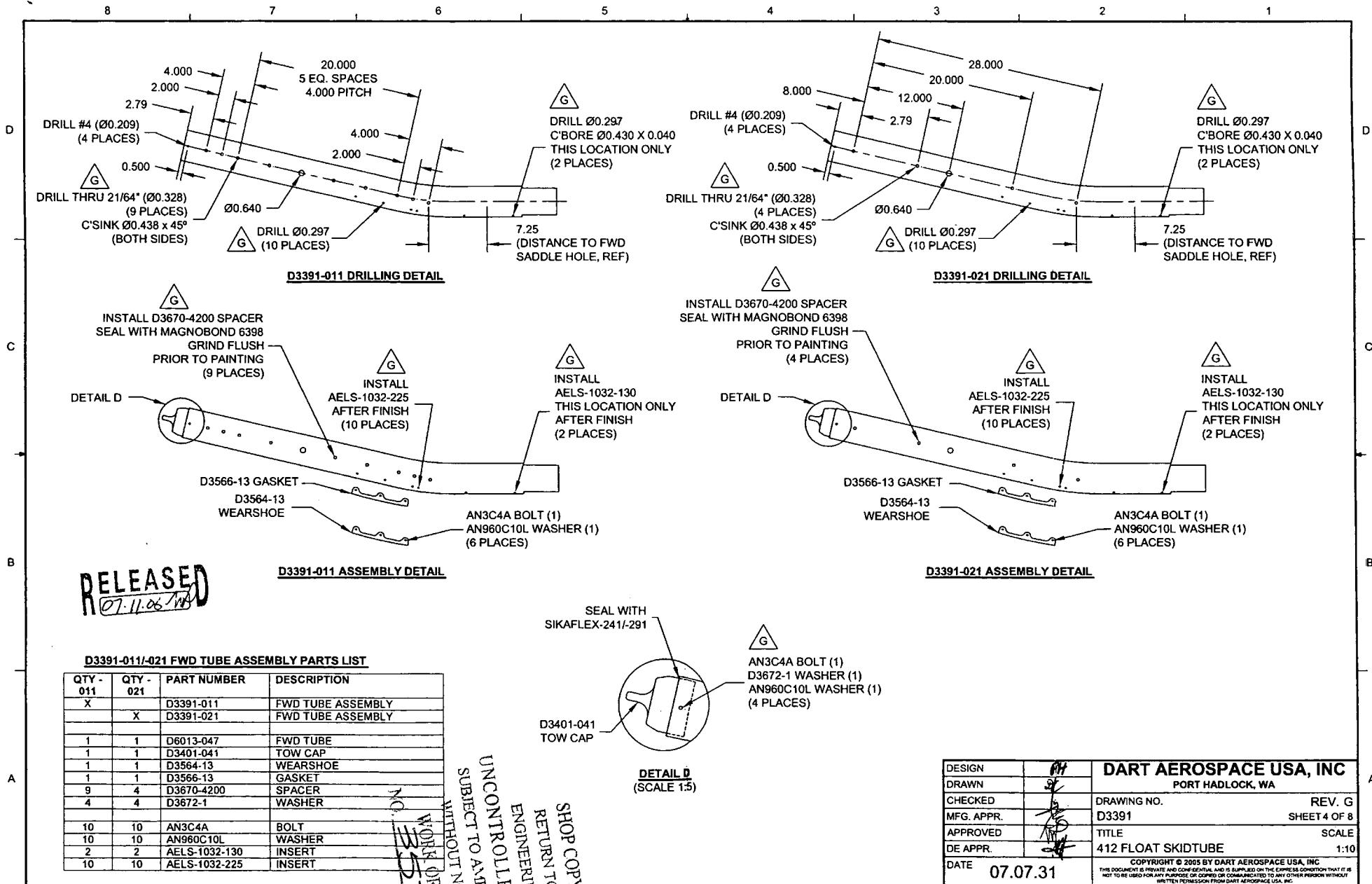
DESIGN	RE	DART AEROSPACE USA, INC
DRAWN	SC	DRAWING NO. D3391
CHECKED	1	REV. G
MFG. APPR.	1	SHEET 2 OF 8
APPROVED	1	TITLE 412 FLOAT SKIDTUBE
DE APPR.	1	SCALE NTS
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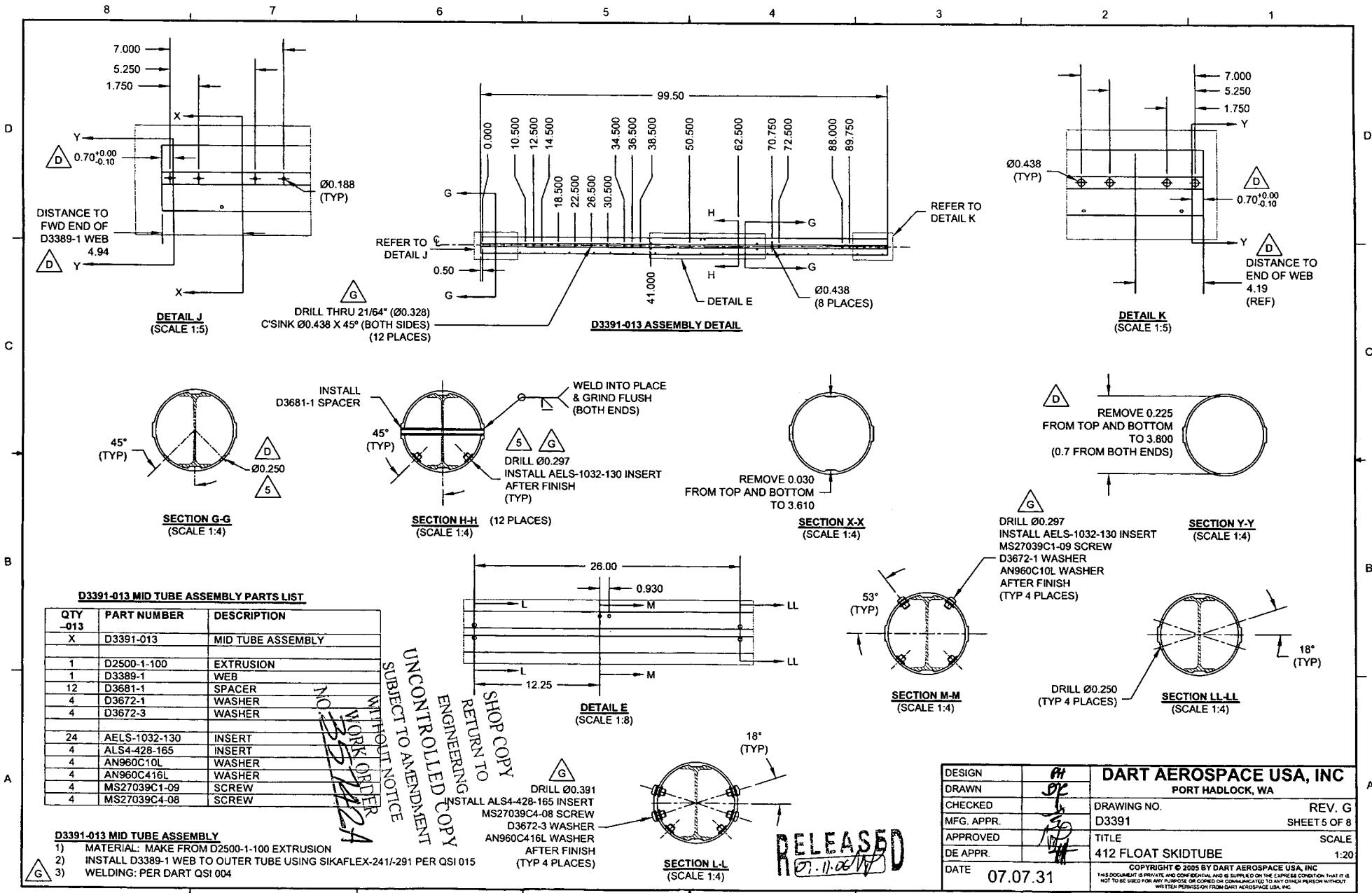
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D3391-013 MID TUBE ASSEMBLY

- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/-291 PER QSI 015
- 3) WELDING: PER DART QSI 004

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ENGINEER SUBJECT TO AMENDMENT
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WORK ORDER
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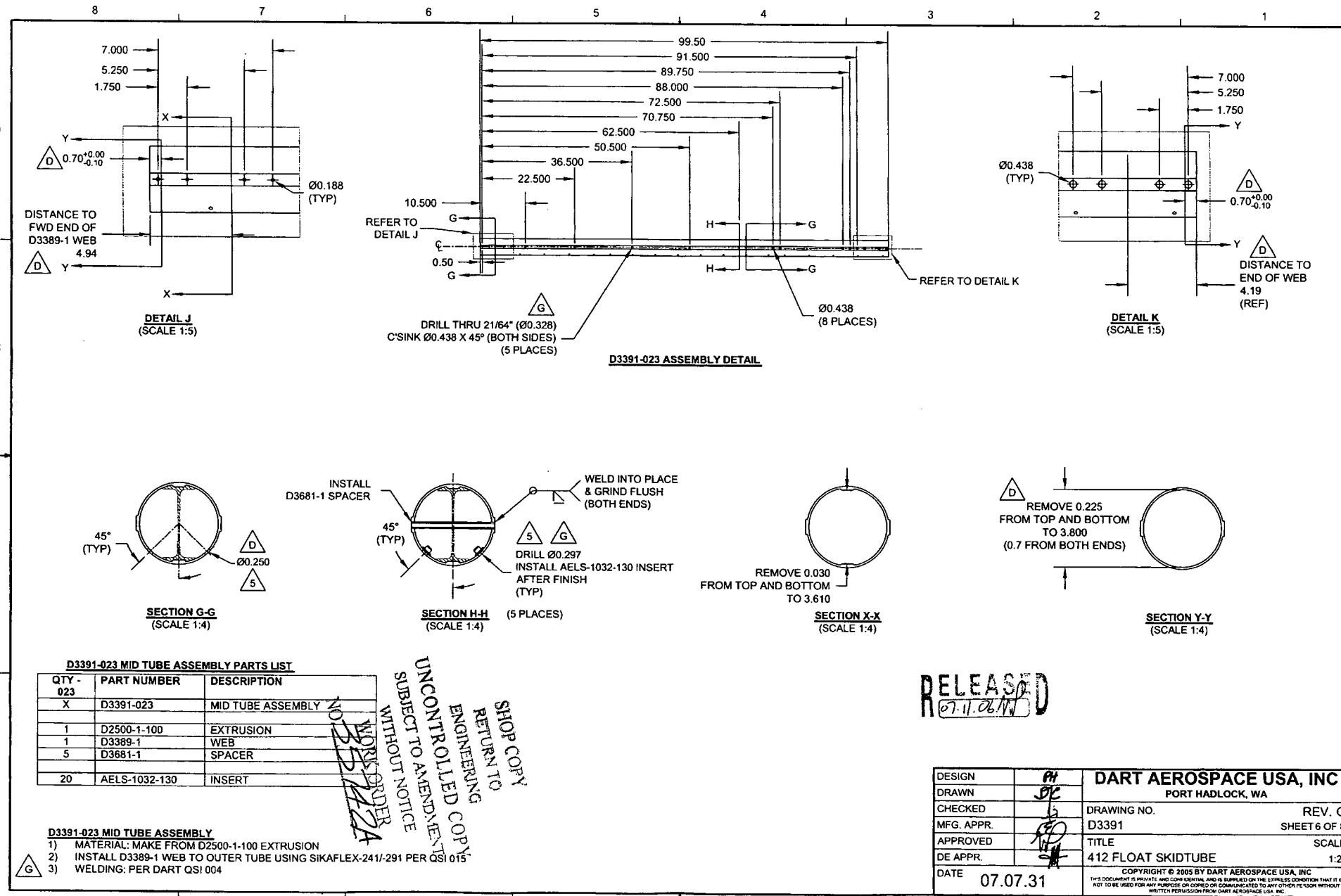
DRILL 0.391
INSTALL ALS4-428-165 INSERT
MS27039C4-08 SCREW
D3672-3 WASHER
AN960C416L WASHER
AFTER FINISH
(TYP 4 PLACES)

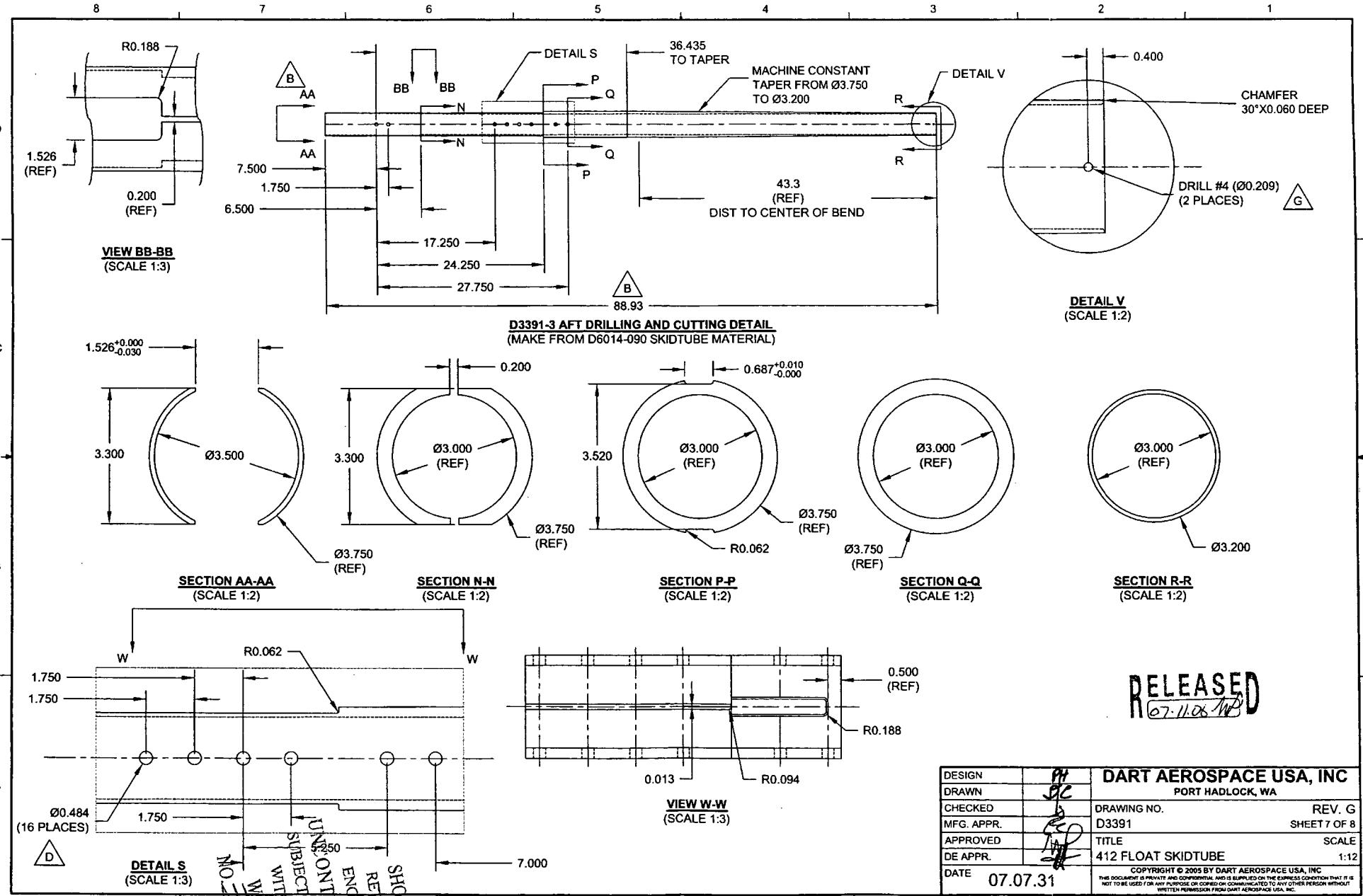
SECTION L-L
(SCALE 1:4)

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MFG. APPR.	<i>SC</i>	D3391	SHEET 5 OF 8	
APPROVED	<i>RP</i>	TITLE	SCALE	
DE APPR.	<i>RP</i>	412 FLOAT SKIDTUBE	1:20	
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MFG. APPR.		REV. G
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